

Date: Thursday, 13/11/2008 11:03:25 AM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: WEARPLATE		
Job Number	: 43427 -2			Part Number	: D33193		
Estimate Number	: 10606			Drawing Number	: D3319 REV. B		
P.O. Number	:			Project Number	: N/A		
This Issue	: 13/11/2008	S.O. No.	:	Drawing Revision	: B		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: SMALL /MED FAB	Due Date	: 20/11/2008		
Previous Run	: 41939			Qty:	12 Um: Each		
Written By	:			split 11			
Checked & Approved By	:						
Comment	: Est: A 05.05.12 New issue KJ/JLM Est Rev:B Now on Waterjet 06-10-03 JLM						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M1010S18GA	1010/1025 SHEET .048	
		Comment: Qty.: 3.4150 sf(s)/Unit Total: 40.9802 sf(s) 1010/1025/A21/6aA SHEET .048" Thick Batch: 10948 NB 8-11-19	
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D3319 Dwg Rev: B FB 8-11-19 Prog Rev: B	(B)
		2-Deburr if necessary FB 8-11-19	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		FB 8-11-19	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK	
			(4)
		Comment: SECOND CHECK	
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr if necessary	u/v Doe at over # 2.2 G glutin

Date: Thursday, 13/11/2006 11:03:26 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: WEARPLATE
Job Number: 43427		Part Number: D33193
Job Number:		
Seq. #:	Machine Or Operation:	Description :
6.0	BRAKE NC	NC BRAKE
Comment: NC BRAKE Form using DT8326 & DT8261 as per Dwg D3319 Rev: <u>6</u>		
7.0	QC6	DIMENSIONAL CHECK
Comment: DIMENSIONAL CHECK		
8.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
Comment: LARGE FABRICATION RESOURCE 1 Weld hard surface using D3319-3T2 per QSI 004 and Dwg D3319 Rev: <u>B</u>		
Qty	Part Number	Description
A/R	N/A	7560 Hardcoat Rod
8.0		Batch <u>M109560</u>
9.0	QC10	VISUAL INSPECTION OF GROUND WELDS
Comment: VISUAL INSPECTION OF GROUND WELDS		
10.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP		
11.0	POWDER COATING	POWDER COATING
Comment: POWDER COATING Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3		
START TIME: OVEN TEMPERATURE: FINISH TIME:	<u>1=00</u> <u>320</u> <u>1=30</u>	<u>4</u> <u>M 6</u> <u>08/11/21</u>
12.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
Comment: INSPECT POWDER COAT		
13.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Identify on inside surface using a permanent fine point marker with the following: TCCA-PDA, Dart Aerospace Ltd.		

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 43427

Part Number: D33193

Job Number:



Seq. #:

Machine Or Operation:

Description :

P/N: D3319-3, B/N: BXXXXX

For Product Eligibility see PDA05-18

and Stock

Location: 497

8/11/21

128 SQ

14.0

QC21

FINAL INSPECTION/W/O RELEASE



08/11/21 AF

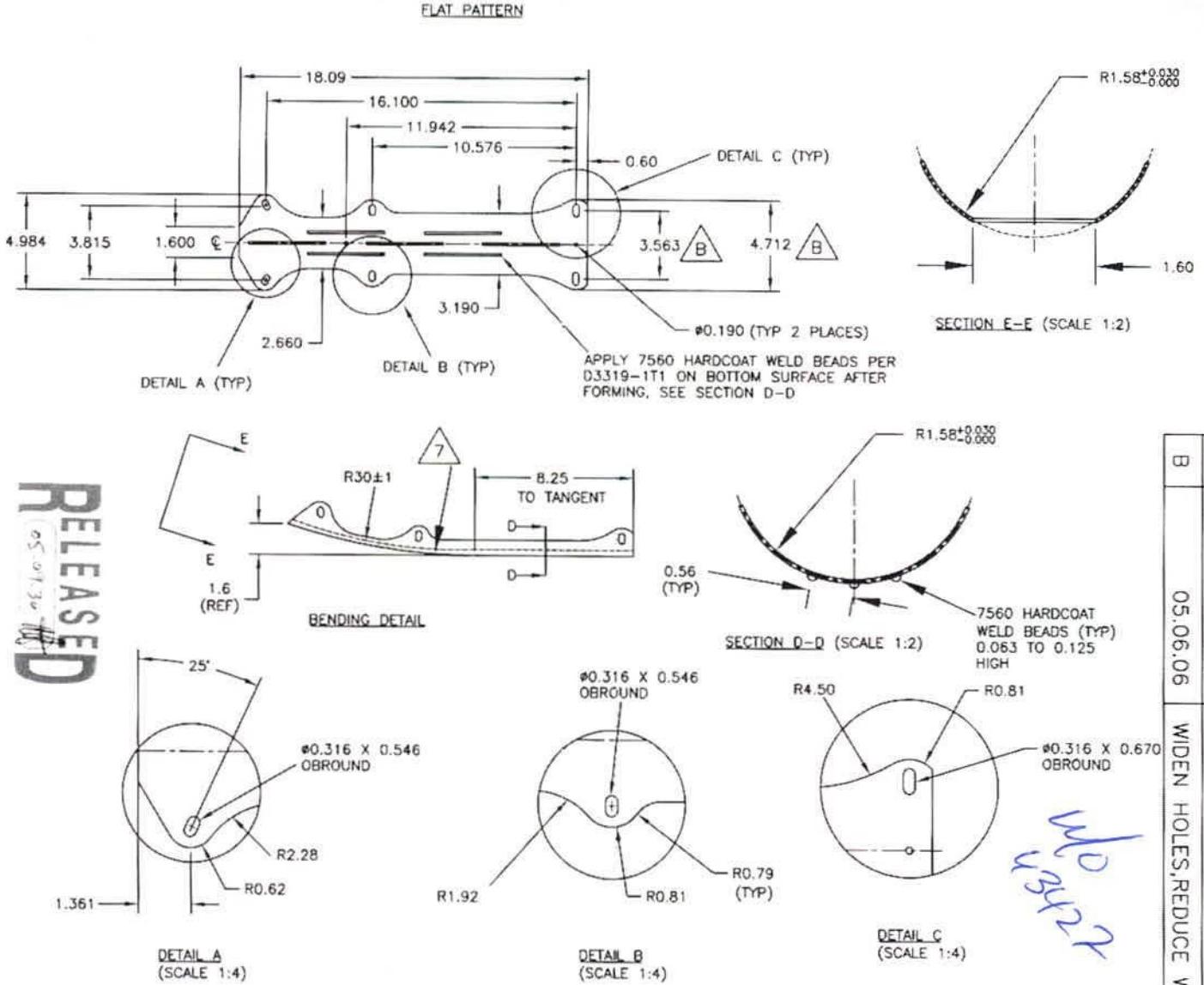
Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-11-21

**RELEASED**

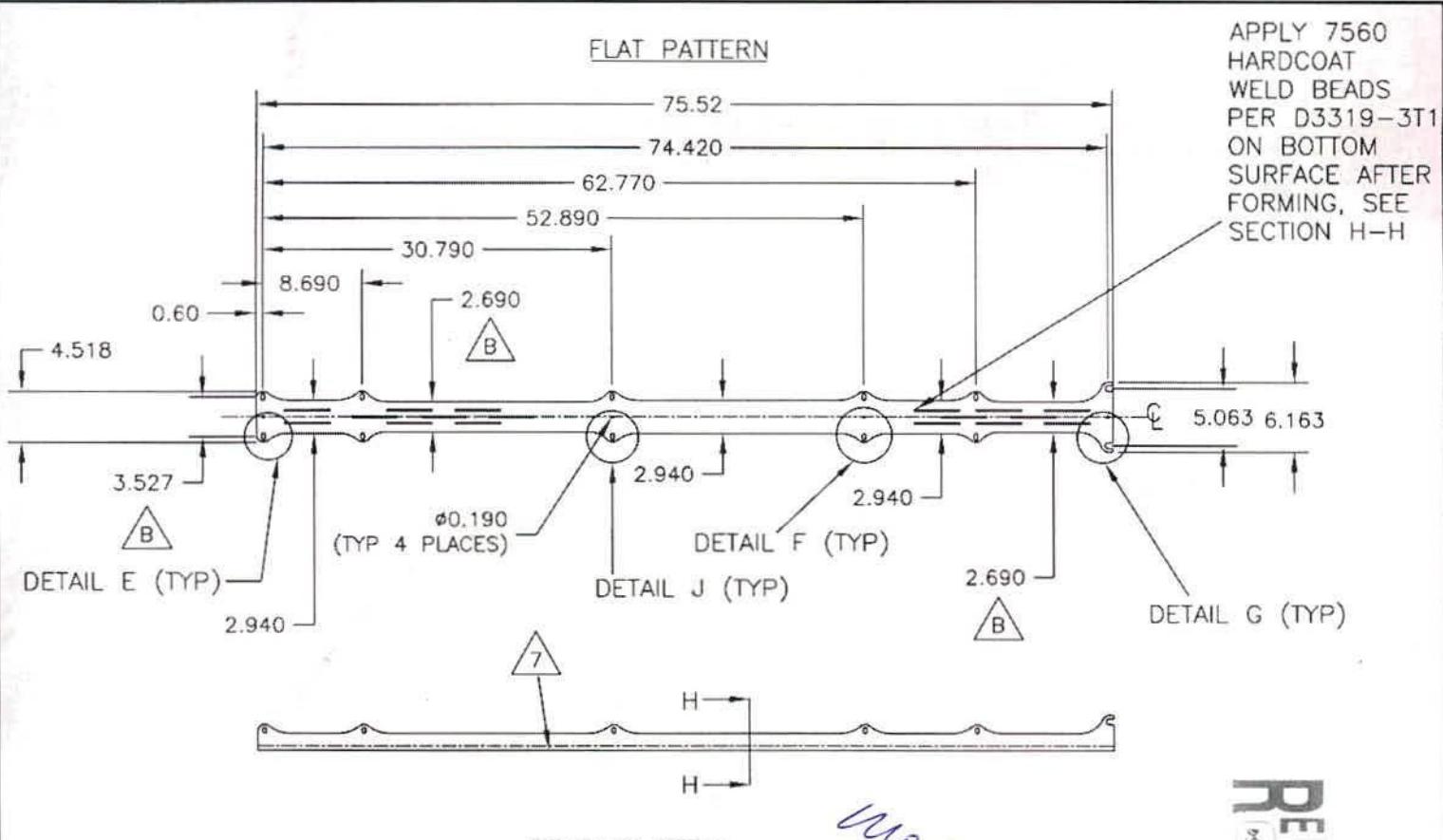


**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD
P41	P41	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
MM	MM	D3319
DATE	DATE	SCALE
05.06.06	04.09.24	SHEET 1 OF 5
A	05.06.06	1:8
B	05.06.06	WEARPLATE
		WD USX27

D3319-3 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:  
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-3 B/N BXXXXXX,  
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

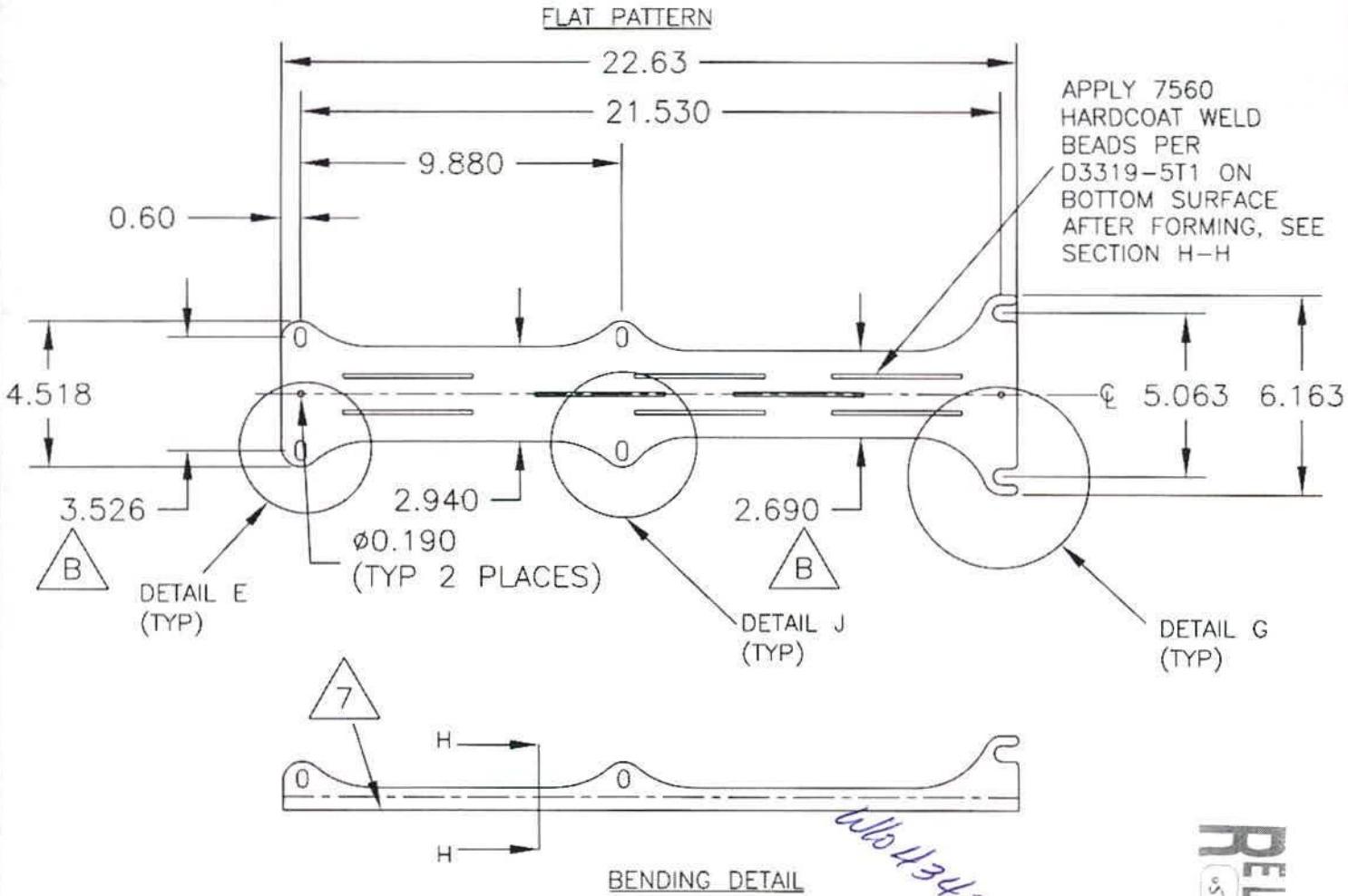


Mo 4/3/27  
**RELEASED**

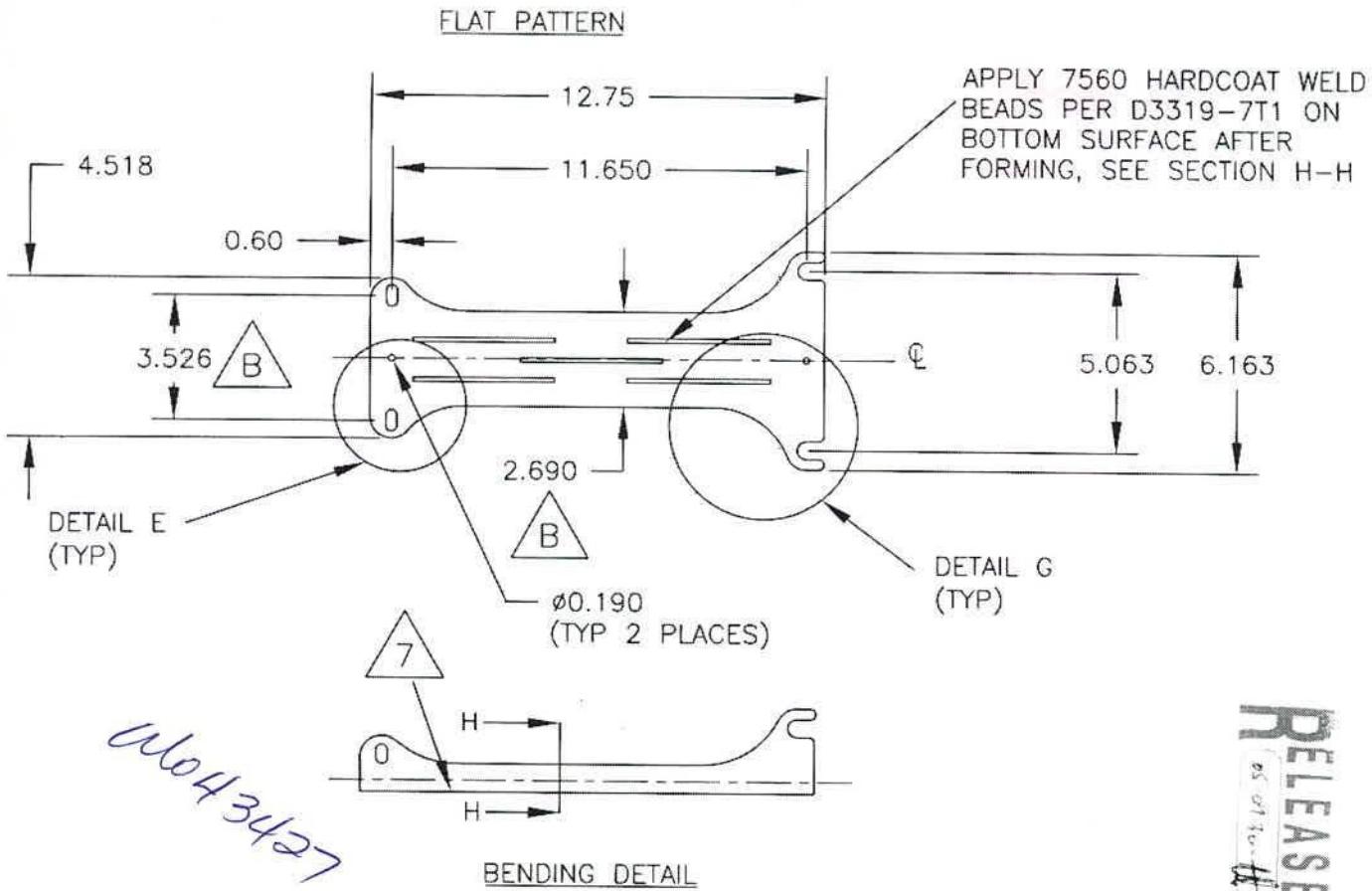
DESIGN <i>A1</i>	DRAWN BY <i>PJ</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>MH</i>	APPROVED <i>MH</i>	DRAWING NO. D3319
DATE 05.06.06		TITLE WEARPLATE
		SHEET 2 OF 5 SCALE 1:15

**DART**

DESIGN P1	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3319
DATE 05.06.06	TITLE WEARPLATE	SHEET 3 OF 5 REV. B SCALE 1:5

**RELEASED****D3319-5 WEARPLATE**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:  
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-5 B/N BXXXXX,  
FOR PRODUCT ELIGIBILITY SEE PDA05-18"



D3319-7 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:  
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-7 B/N BXXXXX,  
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

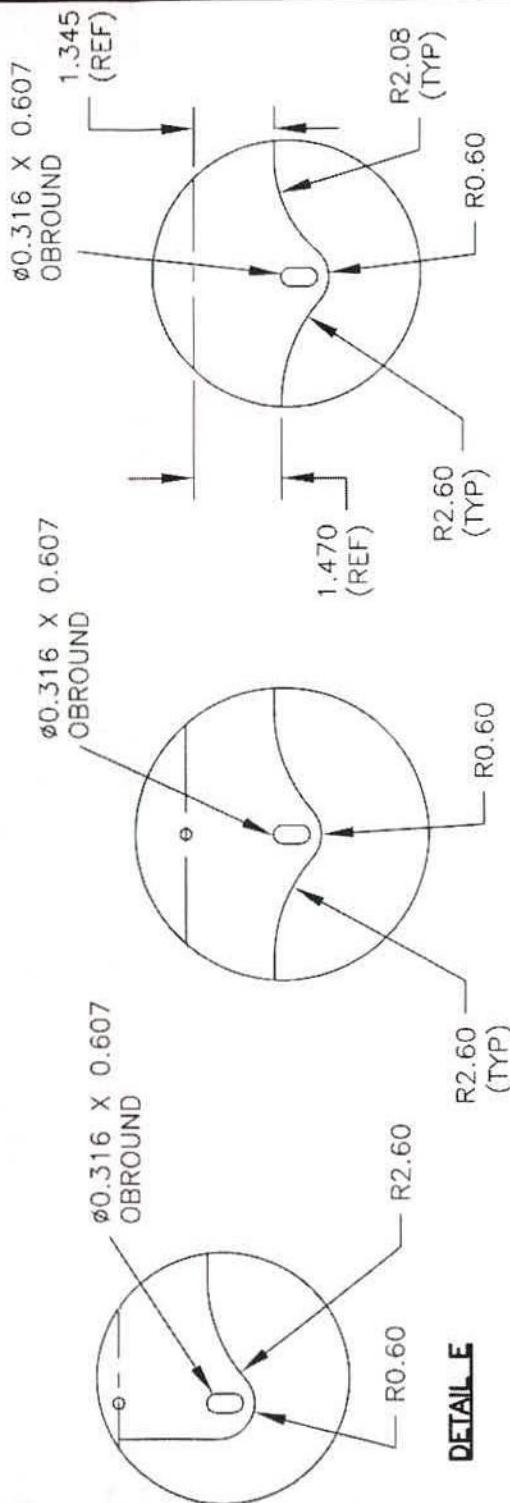
**DART**

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>SH</i>	APPROVED <i>JH</i>	DRAWING NO. D3319
DATE 05.06.06	TITLE WEARPLATE	SHEET 4 OF 5 REV. B
		SCALE 1:5

**RELEASED**  
05.06.06 #

**DART**

DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>JH</i>	APPROVED <i>JH</i>	DRAWING NO. D3319	REV. B SHEET 5 OF 5
DATE 05.06.06		TITLE WEARPLATE	SCALE 1:3

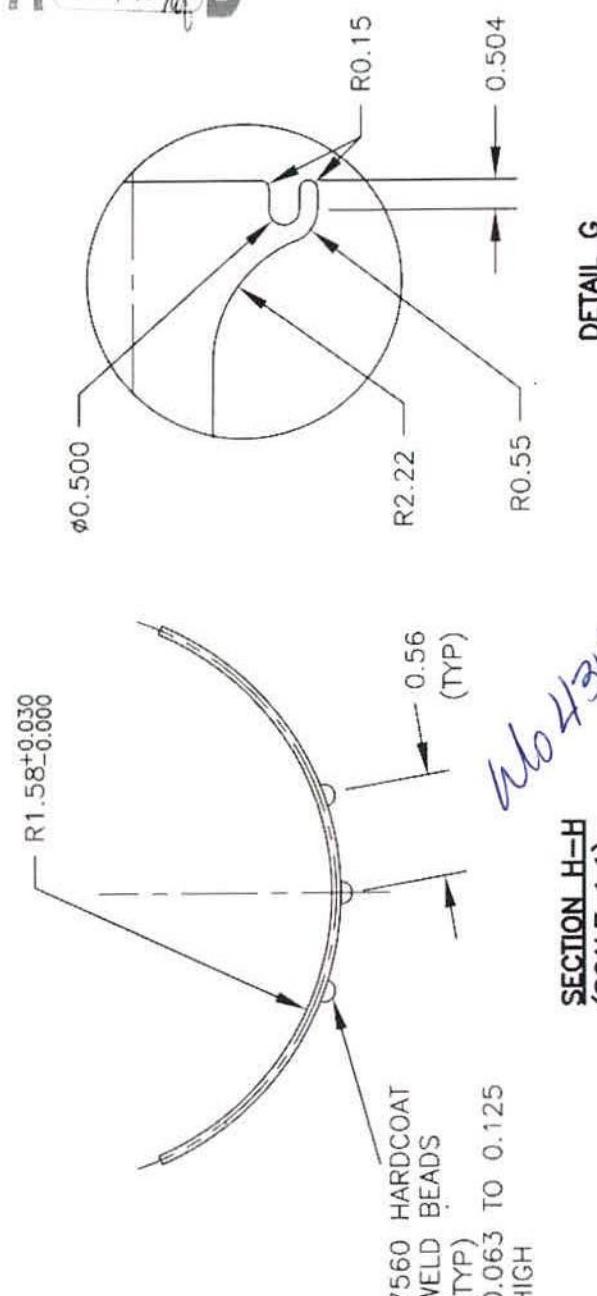


**RELEASED**  
05.07.06

DETAIL J

DETAIL F

DATE  
05.06.06



**SECTION H-H**  
(SCALE 1:1)

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DART AEROSPACE LTD	Work Order:	43427
Description: WEARPLATE	Part Number:	D3319-3
Inspection Dwg: D3319-3 Rev: B		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

First Article       Prototype

<b>Measured by:</b> <u>BS</u>	<b>Audited by:</b> <u>D</u>	<b>Prototype Approval:</b> <u>a</u>
<b>Date:</b> <u>8-11-19</u>	<b>Date:</b> <u>8/11/19</u>	<b>Date:</b> <u>a</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	